

Date:
User:Thursday, 02/04/2009 2:27:37 PM
Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
Job Number	: 46871		
Estimate Number	: 13260		
P.O. Number	:	Part Number	: D350766011
This Issue	: 02/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN350-766 REV A
First Issue	: / /	Project Number	:
Previous Run	: 39940	Drawing Revision	: A
	Type : THERMOFORMING	Material	:
Written By	:	Due Date	: 17/04/2009
Checked & Approved By	: <u>JUD 09.04.03</u>	Qty:	1 Um: Each
Comment	: Est REV A NEW ISSUE 08/04/08 DL verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for CL 09/04/14

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 CHG001

8 09/04/14

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D36551	PANEL
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 39492

8 8 09/04/14 (X)

4.0	D36553	PANEL
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 46879

8 8 09/04/14 (X)

5.0	MS21059L3	Nut Plate
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

batch: M107394

8 8 09/04/14 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)

Job Number: 46871

Part Number: D350766011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	CCR274SS34	Cherry Rivet
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S Comment: Qty.: 8.0000 (s)/Unit Total : 8.0000 (s)
Cherry Rivet
batch: M107438

SS 09/04/14 (X1)

7.0	AN5261032R12	Screw
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S Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M1568

SS 09/04/14 (X1)

8.0	AN5261032R20	Screw
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S Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M10216

SS 09/04/14 (X1)

9.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/04/14 (X1)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-766-011
Location: _____
PPP Rev: B

9/4/14

SS

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/04/15 (X1)

Job Completion



MF 09-04-14

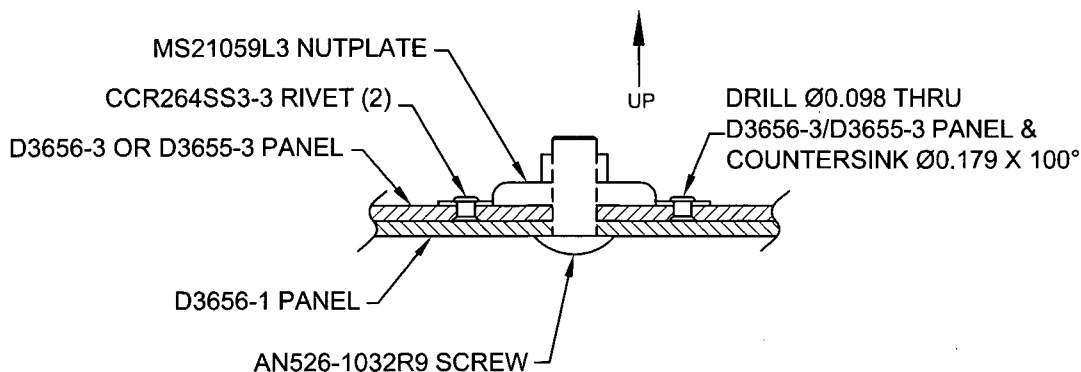
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Figure 6 – Nutplate Installation****4.0 WEIGHT AND BALANCE**

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X	D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
1		D3655-1	PANEL
1		D3655-3	PANEL
	1	D3656-1	PANEL
	1	D3656-3	PANEL
4	15	MS21059L3	NUTPLATE
	30	CCR264SS3-3	RIVET
8		CCR274SS3-4	RIVET
	15	AN526-1032R9	SCREW
2		AN526-1032R12	SCREW
2		AN526-1032R20	SCREW

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NO. 46871R